

Work Order ID 74617

Monday, October 03, 2011 4:06:29 PM



Page 1

Item ID:	D3537-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearpad					
Start Date:	10/3/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/5/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MLJ</u>	Date:	<u>11/10/04</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100	FLOW WATER JET	0.00							
	Waterjet	Memo	0.00						
FLOW CNC Waterjet	1-Cut as per Dwg D3537	<input type="checkbox"/> Dwg Rev: <u>C</u>	<input type="checkbox"/> Prog Rev: <u>C</u>	<input type="checkbox"/> 2-					
304 .003	Deburr if necessary								

B11-10-4

(12)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

B11-10-4

120	QC8- Inspect parts - second check	0.00							
	Control	Memo	0.00						

Sukolos

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3537-7

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 10/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	NC BRAKE					(12)			
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.			SB 11/10/11					
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00		5 11/10/11		(12)			
Quality Control	Ensure joggle as per dwg D3429								
150		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch <input type="checkbox"/> A/R 2059B Hardcoat								
	<input type="checkbox"/> Weld hardcoat as per Dwg D3437								
	m 11/9/06/								

X12 11-01-01 /BL

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Item ID: D3537-7

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Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 10/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QSI004- ground welds

0.00

QPL11-11-10



QC

Memo

0.00

Quality Control

12x

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/11/01 (12)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____ ☐ OVEN TEMPERATURE: _____
FINISH TIME: _____

2:45

4:15

12x 4 m/f 11/11/01

M118439 3200H

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Start Date: 10/3/2011 Start Qty: 10.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				12		BR 11-11-2	
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-1</u>	0.00							
Packaging	Memo	0.00				12		BR 11-11-2	
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							11/11/02
Quality Control									

11-11-02
(12)

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Picklist Print

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Page 1

Work Order ID: 74617



Parent Item: D3537-7



Parent Item Name: Wearpad


Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-12 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	112.1300	0.15	1.578947			



B11-10-7

Location

Loc Qty

Loc Code

MAT020

112.13

118578

16.13

118964

96

118578

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

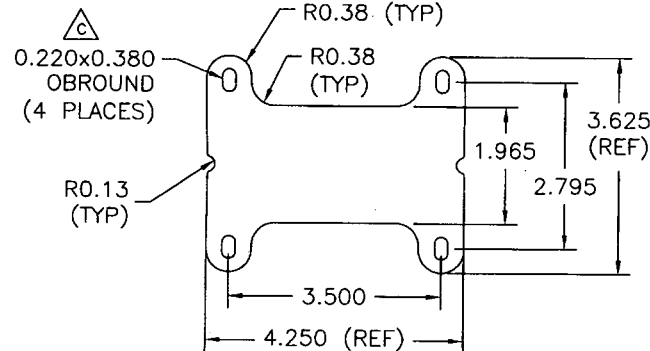
WITHOUT NOTICE
WORK ORDER

NO. 74617

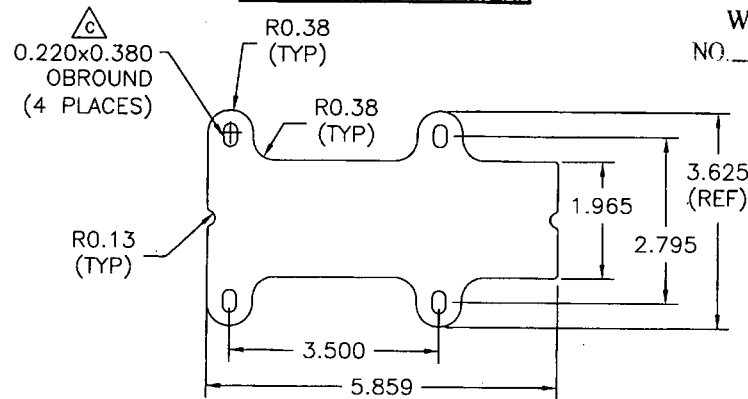
M.L.J.

11/10/04

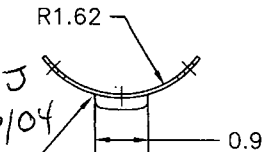
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

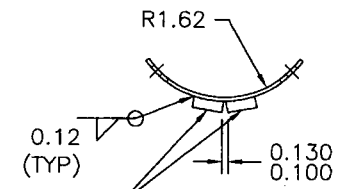


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

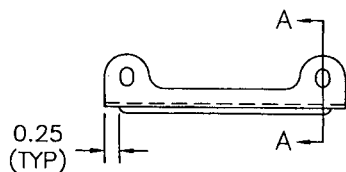
SECTION B-B



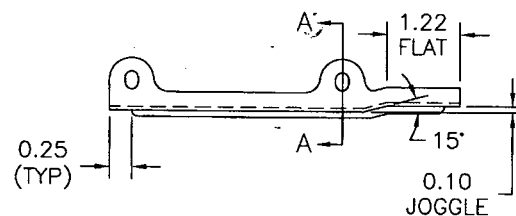
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 AM
PER ECN 952

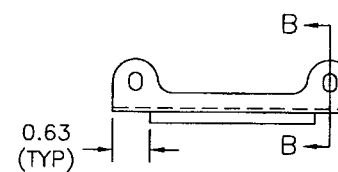
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



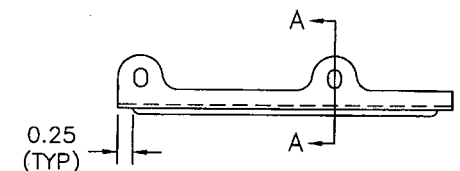
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	A	APPROVED	A	PORT HADLOCK, MA
DATE	07.04.13	TITLE	WEARPAD	REV. C
		DRAWING NO.	D3537	SHEET 1 OF 1
		SCALE	1:2	

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